

# Work Order ID 66100

Friday, February 04, 2011 12:33:58 PM

Page 1

Item ID: D3121-241

Revision ID:

Item Name: Bearing Assembly

Start Date: 2/4/2011 Start Qty: 10.00

Required Date: 2/7/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging



Setup Start



Stop



Cust Item ID:

Customer:



10 - 1 scrap MRF  
11-02-04

10

11-02-03

Curly 10

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Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 2/4/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK

11/02/04

MF  
11-02-04

# Picklist Print

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Work Order ID: 66100

Parent Item: D3121-241

Parent Item Name: Bearing Assembly



Start Date: 2/4/2011

Required Date: 2/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A: 04.02.18 New issue: KJ/DS  
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-25		Manufactured	No				Each	32.0000		10			
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Cap

Location	Loc Qty	Loc Code
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ST234	30	
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65781	30	
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ST235	2	
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58765	2	
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D3121-23		Manufactured	No			130	Each	46.0000	1	10			
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Bearing

Location	Loc Qty	Loc Code
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ST235	46	
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56591	2	
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60708	1	
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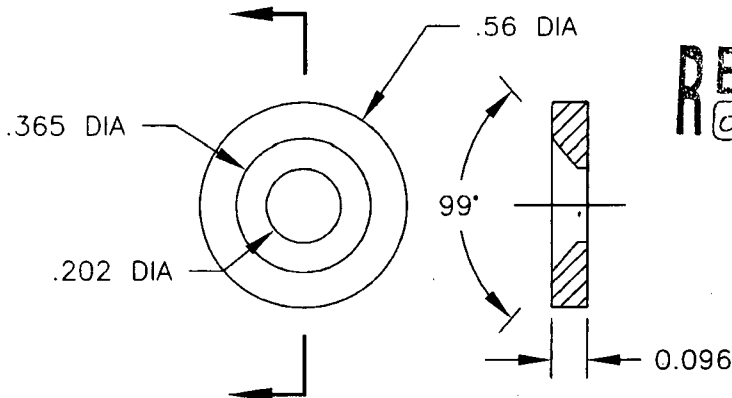
65320	43	
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MF 11-02-04

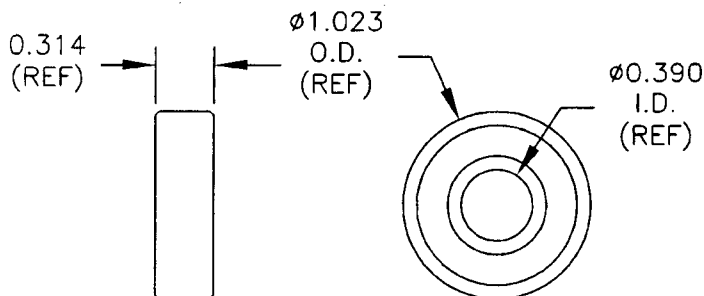
MF 11-02-04

**DART**

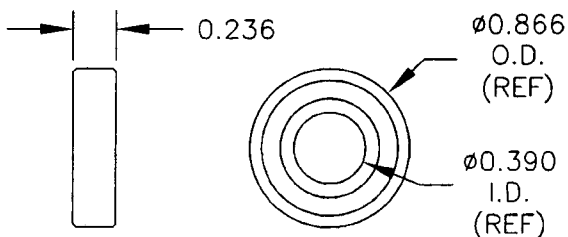
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

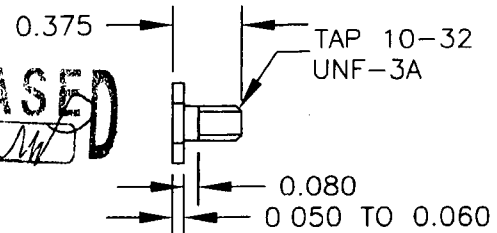
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

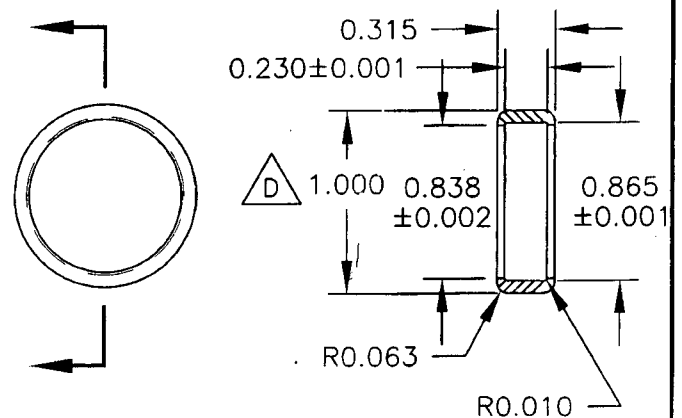
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

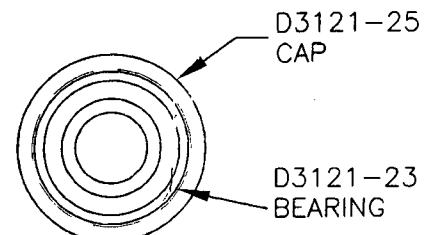
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD,  $\phi$ 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

w/o 66100

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-241 PAR #: \_\_\_\_\_ Fault Category: small fab NCR: Yes No DQA: / Date: 11/02/03  
 Resolution: scrap Disposition: scrap QA: N/C Closed: / Date: 11/02/04

NCR: <u>66100</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-02-03</u>	<u>130</u>	<u>1 part damaged. on the</u> <u>Bearing. Process.</u> <u>1 x D3121-23 B65320 scrap</u> <u>RC-process</u>	<u>[Signature]</u>	<u>Scrap &amp; destroy</u> <u>no replace</u>	<u>[Signature]</u> <u>11/02-03</u>	<u>[Signature]</u> <u>11/02-04</u>	<u>[Signature]</u>	<u>11/02-03</u>

NOTE: Date & initial all entries